

ship. 15 Lev.

Work Order ID 155547

155547

Page 1

Tuesday, January 17, 2017 11:26:05 AM

Item ID: D3078-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Assembly, Hi Short RH

Start Date: 1/10/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/19/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date:

JAN 18 2017

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3078	B								

110

0.00

110

Large Fab

0.14

Large Fab

Memo

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

17-1-27
(4)

120

0.00

120

QC6- Inspect dimensions to drawing

0.01

QC

Memo

Quality Control

1 8 17-01-30

130

0.00

130

Large Fab

0.21

Large Fab

Memo

Large Fab

1-Bevel end for welding FWD ONLY
2-Weld Support, weld Fwd End Plate as per QSI 004 & Dwg D3078
A/R Aluminum Rod m13662/m136158
3-Grind End Plate flush

BE 17-01-30

4 Q.L 17-01-31

DAS
18
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

Work Order ID 155547

Tuesday, January 17, 2017 11:26:05 AM

155547

Page 2

Item ID: D3078-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Assembly, Hi Short RH
Start Date: 1/10/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 1/19/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
140									
QC	Memo	0.01							
Quality Control									
150	QC5- Inspect part completeness to step on W/O ✓	0.00							
150									
QC	Memo	0.01							
Quality Control									
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.01							
Hand Finishing									

DAS 03 4-55

17-2-10

P.T.O.

84

2017/02/13

BEB

DQA:

Date: FEB 28 2017



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: FEB 21 2017

Work Order update only ☐

Work Order: <u>155547</u> Part No. <u>D3078-042</u> NCR No. <u>176301</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☒ Composite ☐ Supplier ☐					
Date: <u>17-02-07</u>		Step #: <u>130</u>		QTY Effective: <u>(1)</u>			MRB (QSI042) Approval DAS 9 9-89 17-02-07		
Description Work Order Deviation				Disposition				Completed By	
found on one step that corner of end cap was grinded to much				-cap cut off and cap and replace using new one D3067-1 B152323 -weld per drawing Aluminum Rod M131562				17-02-08 17-02-08	
								Lead hand // Supervisor Approval Verification DAS 9 9-89 17-02-09	
								QC / QA Coordinator Approval DAS 9 9-89 17-02-09	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☒ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☒ Finish ☒ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐					
OTHER: <u>Grindify.</u>									

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Start Date: 1/10/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 1/19/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC7-Inspect Chemical Conversion Coat	0.00						DAS 43 9-89	FEB 13 2017
170							4x		
QC	Memo	0.01							
Quality Control									

200		0.00						DAS 43 9-89	FEB 13 2017
200	Large Fab						4x		
Large Fab	Memo	0.16							
Large Fab	1- Rivet Leg Assembly as per Dwg D3078.								

2-Bevel Aft end for welding

3-Inspect for foreign object as per QSI 024

4-Weld Aft End Plate as per QSI 004 & Dwg D3078
A/R Aluminum Rod M130855

5-Grind End Plate flush

4x DG 2017/02/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																		
Description Work Order Deviation				Disposition																					
Root Cause		FAULT CATEGORY																							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :																						
Misidentified ☐	☐	Past Due ☐																							

Work Order ID 155547

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155547

Page 4

Item ID: D3078-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Assembly, Hi Short RH

Start Date: 1/10/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/19/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC10- Inspect visual per QSI004- ground welds

0.00

210

QC

Memo

0.01

Quality Control

(4) 17-02-14 PD

220

QC5- Inspect part completeness to step on W/O

0.00

220

QC

Memo

0.01

Quality Control

(4) 17-02-14 PD

230

Touch up alodine

0.00

230

HandFinish

Memo

0.01

Hand Finishing

(4) 2017/02/14
BEB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Revision ID: Stop ***NS2***
Item Name: Step Assembly, Hi Short RH
Start Date: 1/10/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 1/19/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290 *290* Packaging Packaging	Identify as per dwg & Stock Location: _____ Packaging Memo <i>PPP 155659 X4</i>	0.00 0.00				<i>4</i>	<i>DAS</i> <i>21</i> <i>9-89</i>	<i>DAS</i> <i>28</i> <i>9-89</i>	
									FEB 15 2017
300 *300* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.03					<i>DAS</i> <i>21</i> <i>9-89</i>		FEB 16 2017

MF
17-2-15

DQA: _____ Date: _____



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Page 1
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Work Order ID: 155547

155547

Parent Item: D3078-042

D3078-042

Parent Item Name: Step Assembly, Hi Short RH

Start Date: 1/10/2017

Required Date: 1/19/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 15.10.21 NEW ISSUE DD VERF:JLM IPP
REV:B 15.11.12 REV.C3 DD VERF:JLM IPP REV:C
16.03.15 DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3219-3 *D3219-3* Plate		Manufactured	No			130	Each	27.0000	2	4			
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>	**				
					WA003	27							
					145080	27							
D2622-120C *D2622-120C* Step Extrusion		Manufactured	No			130	Each	129.0000	0.5	1			
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>	**				
					WA003	129							
					150070	19							
					152316	110							
D3067-1 *D3067-1* End Plate		Manufactured	No			130	Each	46.0000	1	2			
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>	**				
					WA003	46							
					150703	1							
					152323	45							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 2

Work Order ID: 155547

155547

Parent Item: D3078-042

D3078-042

Parent Item Name: Step Assembly, Hi Short RH

Start Date: 1/10/2017

Required Date: 1/19/2017

Start Qty: 2.00

Required Qty: 2.00

✓ D3066-1

Manufactured No

200 Each 53.0000 2 4

D3066-1

Spacer

**

DG 2017/02/13

Location

Loc Qty

Loc Code

WA003

53

B100479 → 8

150479

27

151991

6

154229

20

✓ MS20600-AD4W4

Purchased No

200 Each 1,409.000 16 32

MS20600-AD4W4

Rivet

**

DG 2017/02/13

Location

Loc Qty

Loc Code

CCK004

1055

B136295 → 64

M135704

55

M136295

1000

ST308

150

M133990

150

WA003

204

M135442

204

✓ D3065-041

Manufactured No

200 Each 8.0000 1 2

D3065-041

Step Leg Assembly

**

DG 2017/02/13

Location

Loc Qty

Loc Code

WA002

8

B154236 → 4

154235

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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								QC / QA Coordinator Approval																	
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

Picklist Print

Tuesday, January 17, 2017 11:26:04 AM

Page 3

Work Order ID: 155547

155547

Parent Item: D3078-042

D3078-042

Parent Item Name: Step Assembly, Hi Short RH

Start Date: 1/10/2017

Required Date: 1/19/2017

Start Qty: 2.00

Required Qty: 2.00

D3067-1

Manufactured No

200

Each

46.0000

1

2

D3067-1

End Plate

****B 156300 → 49-89 FEB 16 2017**

DAS
43

Location

Loc Qty

Loc Code

WA003

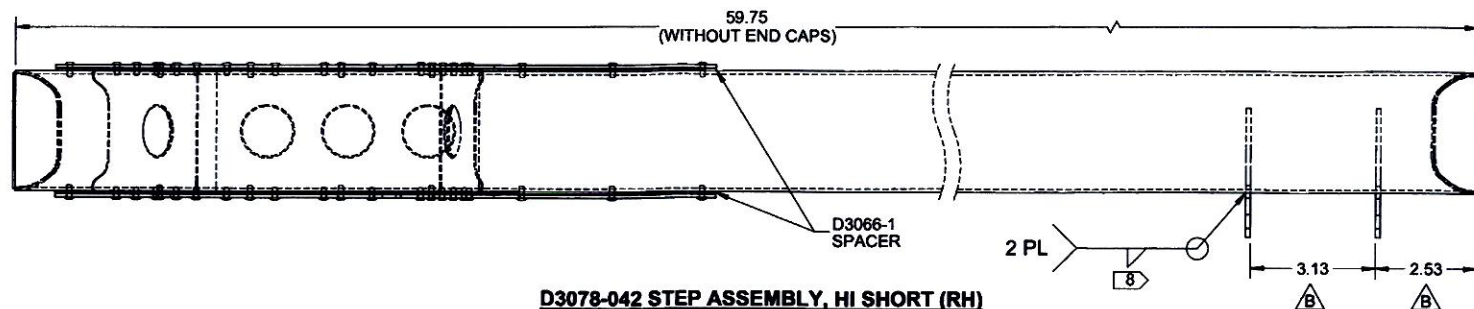
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150703

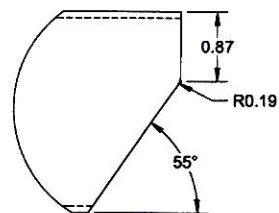
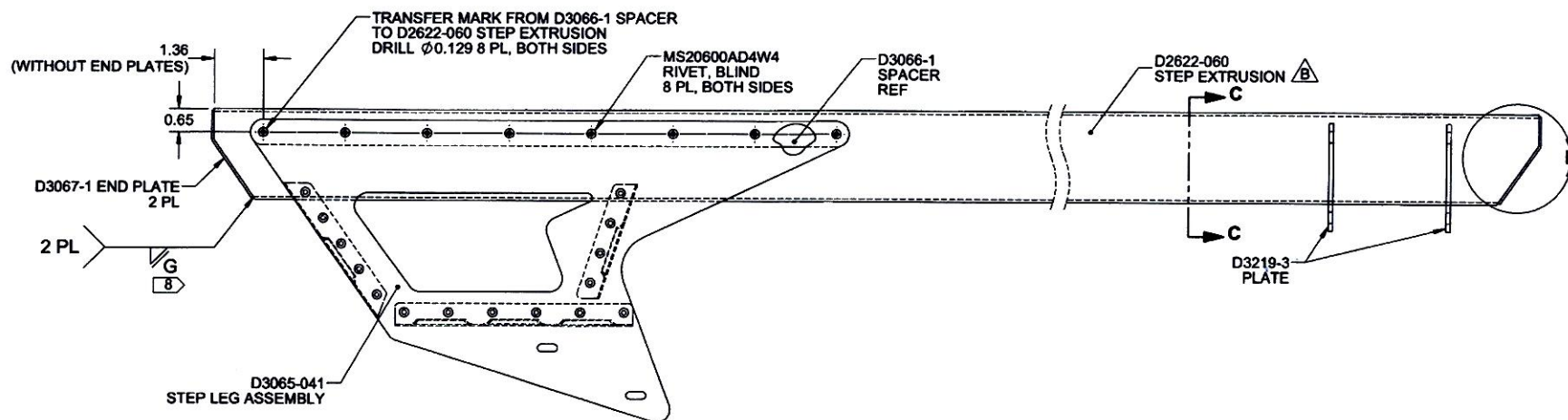
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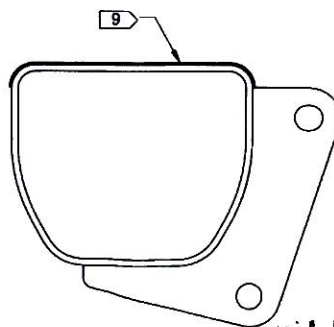
45



D3078-042 STEP ASSEMBLY, HI SHORT (RH)



DETAIL D
2 PL
D3067-1 END PLATE NOT SHOWN
SCALE 2X



SECTION C-C
SCALE 2X

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3078	SHEET 4 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY, HI SHORT	NTS
DATE	15.11.04	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2016-03-14

APPROVED